

IN THE CLAIMS

Claim 1 (original): Process for manufacturing a bag (25, 40) from a polymer and/or metal film material, wherein the lower end of the bag (25, 40) is sealed and the bag comprises of four outer walls (A-D) that are connected by four seams (27), characterized in that the material required for forming the bags (A-E) is fed in the form of a film tube (25, 40) that is wound up on a roll to the unwinding station of a bottom forming device that separates the unwound film tube into film tube segments and seals at least one end of the bag.

Claim 2 (original): Process pursuant to claim 1, characterized in that a film tube (25) is used that already comprises side gussets (26).

Claim 3 (currently amended) Process pursuant to ~~one of the aforementioned claims~~ claim 1, characterized in that the bottom of the bag is formed using transverse sealing.

Claim 4 (currently amended): Process pursuant to ~~the preceding claim~~ claim 1, characterized in that the bottom of the bag is formed exclusively by a squeezing process and a transverse sealing process.

Claim 5 (currently amended): Process pursuant to ~~one of the aforementioned claims~~ claim 1, characterized in that the bottom formation of the bag is followed by a filling process of the bags.

Claim 6 (currently amended): Process pursuant to ~~one of the~~

~~aforementioned claims~~ claim 1,

characterized in that

the top end of the bags is also sealed using transverse sealing.

Claim 7 (currently amended): Process pursuant to ~~one of the~~
~~aforementioned claims~~ claim 1,

characterized in that

the bag is formed and filled partly in a form, fill and seal machine.

Claim 8 (currently amended): Process pursuant to ~~one of the~~
~~aforementioned claims~~ claim 1,

characterized in that

a film tube (25, 40) is used in which at least one part of the four seams of the film tube is formed by a joining process in which additional joining material, such as adhesives or extrudates, is applied on the seam (27).

Claim 9 (currently amended): Process pursuant to ~~one of the~~
~~aforementioned claims~~ claim 1,

characterized in that

a film tube (25, 40) is used that is formed out of four film webs (A-D) that are fed parallel to one another by film supply devices to a joining station (8).

Claim 10 (currently amended): Process pursuant to ~~the preceding~~
~~claim~~ claim 1,

characterized in that

the conveying direction of the four film webs to the joining station (8) defines the longitudinal axis of the formed film tube (25, 40).

Claim 11 (original): Tubular film roll (36) formed out of a film tube with four side walls (A-D) that are joined to one another

using four seams (27).

Claim 12 (original): Tubular film roll (36) pursuant to claim 11, characterized in that two (BC) of the four side walls (A-D) have side gussets (26).

Claim 13 (original): Tubular film roll (36) pursuant to claim 12, characterized in that the front sides (A, D) of the side-gussetted film tube (25) lie over one another.

Claim 14 (currently amended): Tubular film roll (36) pursuant to claim 12 [or 13], characterized in that the side gussets (26) are staved toward the direction of the tube axis.